

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
17 March 2005 (17.03.2005)

PCT

FA1116
(10) International Publication Number
WO 2005/023437 A2

(51) International Patent Classification⁷: B05D
(21) International Application Number:
PCT/US2004/028920
(22) International Filing Date:
3 September 2004 (03.09.2004)
(25) Filing Language: English
(26) Publication Language: English
(30) Priority Data:
60/499,651 3 September 2003 (03.09.2003) US

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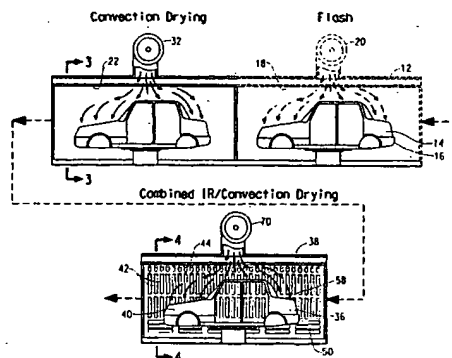
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(81) Designated States (unless otherwise indicated, for every
kind of national protection available): AE, AG, AL, AM,
AT, AU, AZ, BA, BB, BG, BR, BW, BY, BZ, CA, CH, CN,
CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, EG, ES, FI,
GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE,
KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD,
MG, MK, MN, MW, MX, MZ, NA, NI, NO, NZ, OM, PG,
PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM,
TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM,
ZW.

(84) Designated States (unless otherwise indicated, for every
kind of regional protection available): ARIPO (BW, GH,
GM, KE, LS, MW, MZ, NA, SD, SL, SZ, TZ, UG, ZM,
ZW), Eurasian (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM),
European (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI,
FR, GB, GR, HU, IE, IT, LU, MC, NL, PL, PT, RO, SE, SI,
SK, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ,
GW, ML, MR, NE, SN, TD, TG).

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(54) Title: MULTI-STAGE PROCESSES FOR DRYING AND CURING SUBSTRATES COATED WITH AQUEOUS BASECOAT
AND A TOPCOAT



(57) Abstract: A multi-stage process for drying and curing substrates coated with liquid waterborne basecoat and a topcoat includes:
(a) applying a liquid waterborne basecoating composition to the substrate surface; (b) exposing the basecoating composition to air
having a temperature ranging from ambient to about 40° C for a period of about 30 seconds to volatilize at least a portion of volatile
material from the liquid basecoating composition, the velocity of the air at the surface of the basecoating composition being about 0.3
to about 1 meter per second; (c) applying heated air to the basecoating composition for a period ranging from about 30 to about 45
seconds, the velocity of the air at the surface of the basecoating composition ranging from about 1.5 to 15 meters per second, the air
having a temperature ranging from about 30° C to about 90° C; (d) applying infrared radiation and heated air simultaneously to the
basecoating composition for a period of ranging from about 30 to 45 seconds, the velocity of the air at the surface of the basecoating
ranging from about 1.5 to 5 meters per second, the air having a temperature ranging from about 30° C to about 60° C, such that a
sufficiently dried basecoat is formed upon the surface of the substrate; (e) applying a topcoating composition over the basecoat; and
(f) simultaneously curing the basecoating composition and the topcoating composition together.

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Published:

— without international search report and to be republished upon receipt of that report

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